

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 129954

129954

Page 2

February-23-15 10:34:24 AM

Item ID: D2435 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 2/23/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00				4			DAS 14 9-89
150									
QC	Memo	0.00							
Quality Control									15/03/11
151	Identify as per dwg & Stock Location: <u>St</u>	0.00				4			MAR 16 2015
151									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

Handwritten signature and date 1503-16

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Picklist Print

February-23-15 10:34:24 AM

Page 1

Work Order ID: 129954

129954

Parent Item: D2435

D2435

Parent Item Name: Bearpaw

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	122.8895	3.2	13			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

2/15/02/27

Location

MAT018

m128092

m131335

131661

Loc Qty

122.8895

1.7225

121.167

Loc Code

16

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DART AEROSPACE LTD		Work Order:	129954
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.063	✓		6" Vern	B605
B	5.500	+/-0.030	5.502	✓		"	"
C	0.200	+/-0.030	.195	✓		"	"
D	R0.250	+/-0.030	.250	✓		"	"
E	0.250	+/-0.010	.258	✓		"	"
F	0.625	+/-0.030	.635	✓		"	"
G	0.25 x 45°	+/-0.030	.245	✓		"	"
H	0.375	+/-0.010	.385	✓		"	"
I	19.000	+/-0.030	19.00	✓		Tape	B607
J	0.950	+0.030/-0.010	.960	✓		Vern	B605
K	Ø0.260	+0.005/-0.000	.260	✓		"	"
L	Ø0.930	+/-0.030	.930	✓		"	"
M	0.30	+0.030/-0.000	.300	✓		"	"
N	0.375	+/-0.030	.380	✓		"	"
O	7.375	+/-0.030	7.375	✓		Tape	B607
P	4.250	+/-0.010	4.255	✓		"	"
Q	2.000	+/-0.030	1.990	✓		"	"
R	9.000	+/-0.010	9.000	✓		"	"
S	15.750	+/-0.030	15.75	✓		Tape	B607

Measured by: B6	Audited by: DAS 14	Prototype Approval:	N/A
Date: 15-03-11	Date: 15-03-11	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	



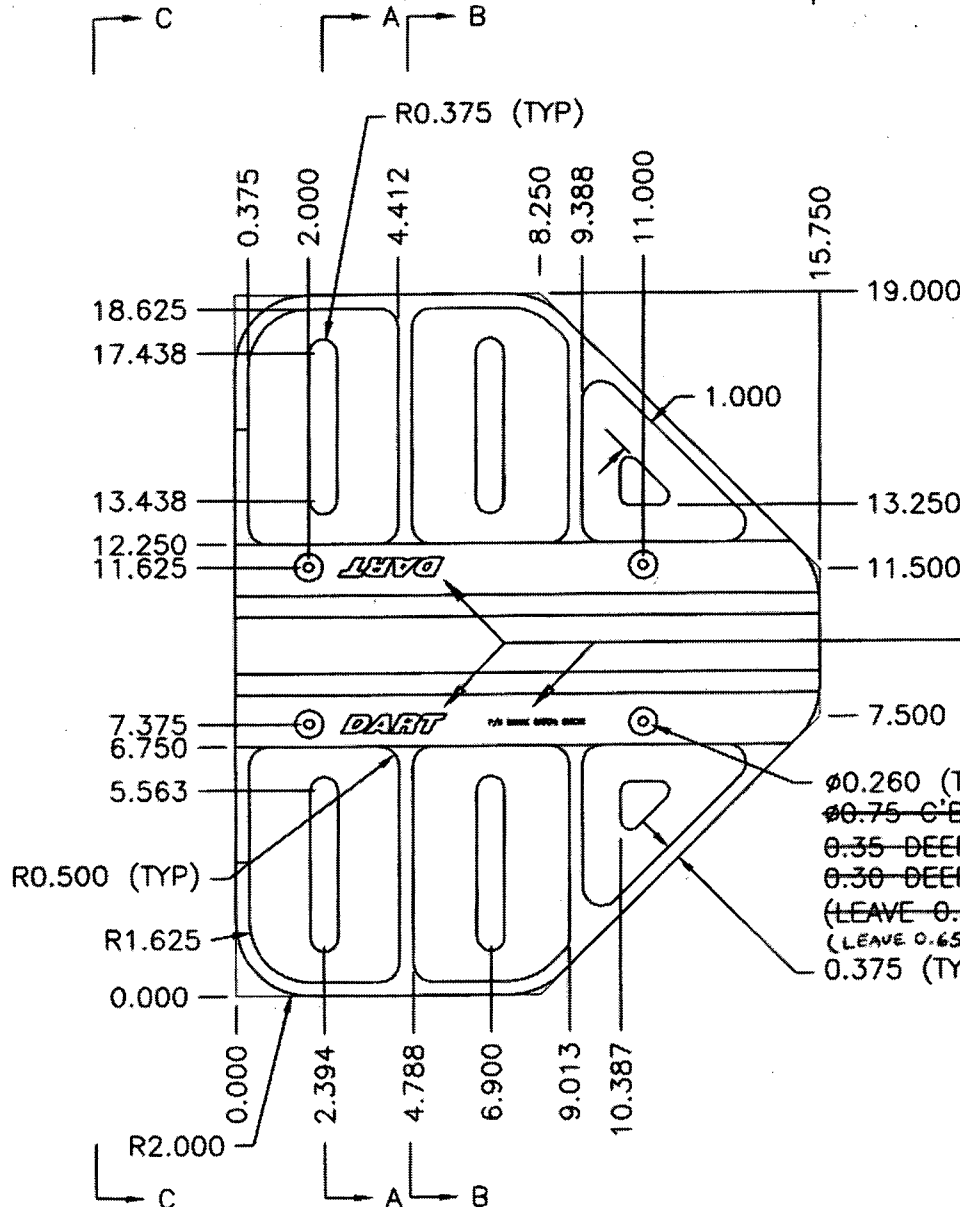
RELEASED
98.06.17 KE

DESIGN	DRAWN BY	DART Aerospace Ltd HAMKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED KE	
DATE 98.05.19	TITLE BEARPAW	REV. E SHEET 1 OF 2
A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

NO 129954 ML5
15-02-25

E1 02.12.17 $\phi 0.93$ WAS $\phi 0.75$ ~~FEA~~



$\phi 0.260$ (TYP) $\phi 0.93$ C'BORE
 ~~$\phi 0.75$ C'BORE~~ 0.30 DEEP FROM BOTTOM
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375 (TYP)

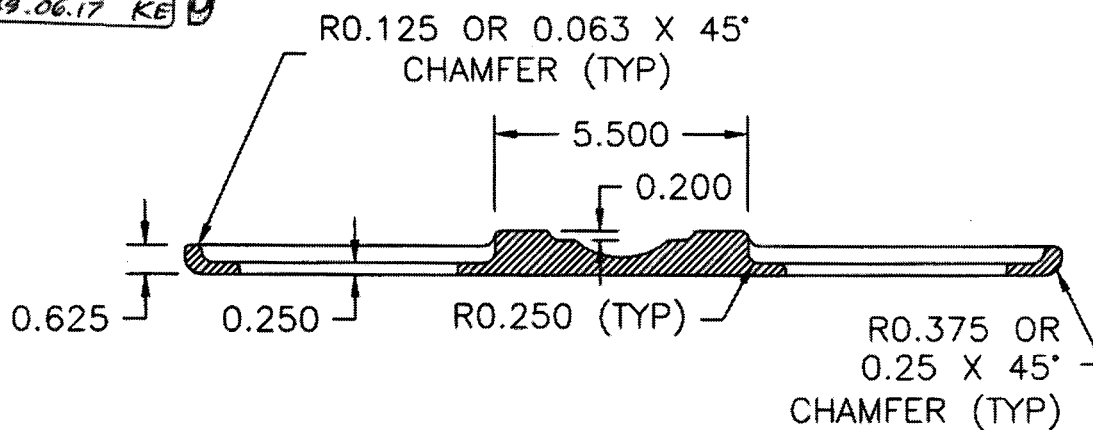
9143

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

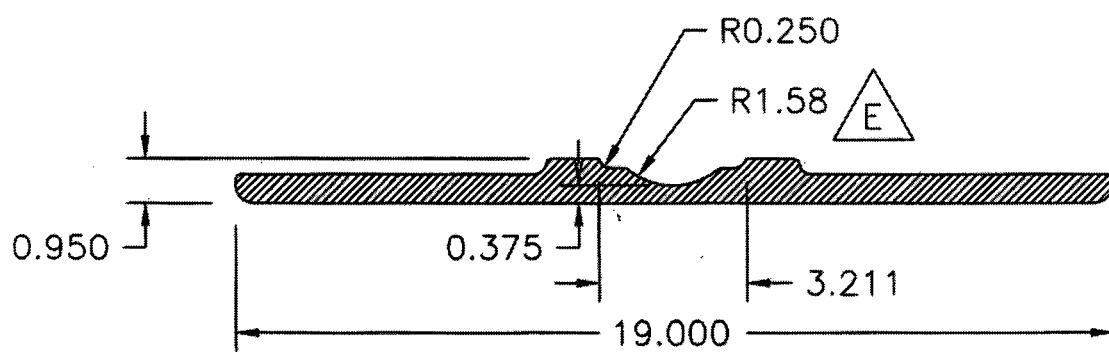


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

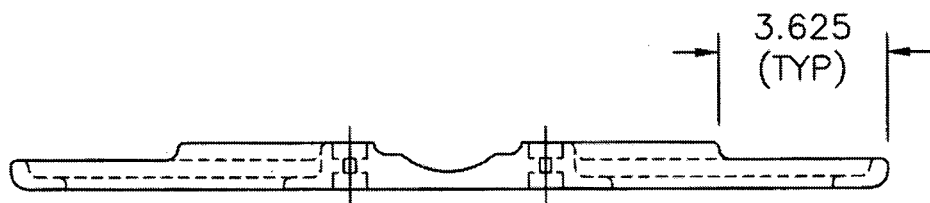
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C